

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 72.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016123**Date Inspected:** 27-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1230**Contractor:** Lubrite**Location:** Meadville, PA

CWI Name:	Dean Gamble		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** Spherical Bushing Ring Bearing (Hinge K)**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon was present at Lubrite Technologies in Meadville, PA as requested to witness stud welding the Procedure Qualification Record (PQR) for the Spherical Bushing Ring Bearing (Hinge K) Bid item #46(S) to be used on the San Francisco / Oakland / Bay Bridge (SFOBB), Self Anchored Suspension (SAS).

QA Inspector Brannon met with QCM Mr. Brad McWright and was provided Material Test Reports (MTR) for the following materials: Base Material - ASTM A709, Grade 50, heat number 0502434 and Stud Material - Nelson Stud, ASTM A108/A29 Grade 1015, 1" x 8-1/4" (size), heat number 5093721 and with mechanical properties to AWS D1.5:2002 Table 7.1 Type B and Ferrule Material -Full base ceramic ferrule number 100101045. QA Inspector Brannon reviewed the MTR and verified the materials as they were presented, which appeared to comply with contract documents.

QA Inspector Brannon witnessed Lubrite welder Mr. Gregg Zimmerman perform the stud welding for Stud Welding Procedure Qualification Record (PQR) number 9103823. QA Inspector Brannon observed CWI Mr. Dean Gamble monitor the PQR test and perform the applicable inspections. See Caltrans Welding Witness Report, TL-6032 dated July 27, 2010 for additional information.

WELDING INSPECTION REPORT

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Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer